

ABSTRACT OF THE DISCLOSURE

A multi-stage tube forging method for disproportionally enlarging an end section of an aluminum alloy tube of a bicycle frame part includes
5 the steps of (a) drawing the tube to form a thin section and a thick end section, (b) radially and proportionally enlarging the cross-section of the thick end section of the tube by forging the tube in such a manner that the wall thickness of the thick
10 end section after being enlarged is substantially the same as that of the thin section, and (c) disproportionally varying the cross-section of the thick end section of the tube by forging the tube obtained in step (b).